

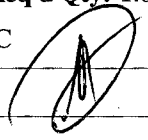
Work Order ID 160434

Thursday, April 27, 2017 11:36:28 AM

160434

Page 1

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 5/23/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/13/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan:  Date: APR 27 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4464	H								

100 Weld per dwg A/R Aluminum rod Batch: 3136158 0.00

100

Large Fab

Large Fab

Memo

3.19

1- Weld D4023-3 cap as per dwg D4464

2- Buff alodine on all edges welded parts.

Achtung!
 Vor Einbau Sicherungsstift herausnehmen
Attention,
 remove safety pin before installation
Atenção!
 Remova o pino de segurança antes de montar

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.02

① 17-05-31

DAS
9
9-89

112

112

Small Fab

Small Fab

Memo

2.46

Wet install baffles to front and back panel using rivet and Proseal as per dwg

A/R Proseal Batch: 136753

1X 17-06-05

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 160434

Thursday, April 27, 2017 11:36:28 AM

160434

Page 2

Item ID: D4464-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fuel Tank Assembly

Start Date: 5/23/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114	QC5- Inspect part completeness to step on W/O	0.00			DAS				
114					30	1			MAY 05 2017
QC	Memo	0.02			9-89				
Quality Control									

120

Weld per dwg A/R Aluminum rod Batch: **B131562*****120***

Large Fab

Memo

2.42

Large Fab

1- Use fixture to weld D4125 bolws to D4463-13 as per dwg.

2- Tack Weld D4463-3 to side, front a back panel.

14 CC 176-8

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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160434

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/13/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: SCHEDULED/C

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

DAS
36
9-89

123

0.00

123

1.00

Small Fab

Small Fab

Memo

Transfer drill and c/sink D4975-1 bracket to bottom bracket , wet install as per dwg

Proseal 890B Batch: 136953

Install hinge wet with proseal as per dwg.
A/R Proseal 890B Batch: 136953

Instal D4000-9 grommets as per dwg, ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG***

Install fitting D4000-1 wet with proseal as per dwg
A/R Proseal 890B Batch: 136953

140

Weld per dwg A/R Aluminum rod Batch: B/3/562 0.00

140

Memo

1.00

Large Fab

Finish welding the rest of the tank.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 160434

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160434

Page 4

Item ID: D4464-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 5/23/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/2017 Req'd Qty: 1.00

1

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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141

QC9- Inspect visual per QSI004- Fusion Welds

0.00

141

QC

Memo

0.02

Quality Control

① 17-06-13
DAS
9
9-89

142

QC5- Inspect part completeness to step on W/O

0.00

142

QC

Memo

0.02

Quality Control

Pressure Test as per dwg D4464

① 17-06-13
DAS
9
9-89

143

Outsource process - NDT per QSI038 4.1

0.00

143

Outsource2

Memo

180.00

Outsource process - NDT

ISSUE P/O:

LPI INSPECTION

C OF C IS REQUIRED

/ JUN 21 2017
DAS
13
9-89

/ JUN 21 2017
DAS
13
9-89

34694
36750

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: <u>160434</u> Part No. <u>D4464-041</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				17-06-13 Completed By <u>[Signature]</u> 17/06/28 Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Remove "pressure test". Not applicable will be perform on seq. 169									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 160434

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160434

Page 5

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 5/23/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/13/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	Receive & Inspect for Damage & Mat'l Certs	0.00							
145									
Packaging	Memo	0.02							
Packaging									
147	QC6- Inspect dimensions to drawing	0.00							
147									
QC	Memo	0.02							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	1.48							
Hand Finishing	1- Alodine on tank. No alodine inside								

DAS
38
9-89
JUN 21 2017

2017/06/21
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Thursday, April 27, 2017 11:36:28 AM

160434

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/13/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: SCHEDULED/C

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

160

OC

Memo

0.01

Quality Control

164

0.00

164

Small Fab

Memo

1.48

Small Fab

1- Brush Proseal 890A on all internal sheet metal folds
Proseal 8990A Batch: 136953

2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B

A/R Proseal 890B Batch: 136955

169

QC5- Inspect part completeness to step on W/O	0.00
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169

OC

Memo

0.02

Quality Control

Pressure Test as per dwg D4464

DA.
38
9-89

JUN 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 160434

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Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 5/23/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/13/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							DAS 41 9-89
170									
SprayPaint	Memo	1.05							
Spray Painting	***MASK PROIOR PRIME AND PAINT AS PER DWG***								
	PRIME TEMPO GREY AS PER DWG AND QSI								
	PRIMER BATCH: <u>137487</u>								
	PAINT FLAT GREY AS PER DWG AND QSI								
	PAINT BATCH: <u>136996</u>								
180	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
180									
QC	Memo	0.01							
Quality Control	***Pressure Test as per dwg D4464***								

JUN 26 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		PD 17-06-13 17-06-13	
to be remove, not applicable				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 160434

Thursday, April 27, 2017 11:36:28 AM

160434

Page 8

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 5/23/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/13/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: % Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190									
Small Fab									
Small Fab	Memo	1.84							
	1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg								
	2- Abrade surface with red scotch brite and install cushion using contact cement								
	A/R Contact Cement Batch: <u>137275</u>								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC									
Quality Control	Memo	0.02							
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging									
Packaging	Memo	0.01							

DAS 36 9-89 17/06/26 PTO →

DAS 38 9-89 JUN 27 2017

DAS 27 9-89 17/6/27

PPP 160158

DQA:

Date: 2017-07-10QA Closed: [Signature]Date: JUN 28 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>160434</u> Part No. <u>D4464-041</u> NCR No. <u>17-6469</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																																									
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Date: <u>17-06-26</u>		Step #: <u>190</u>		QTY Effective: <u>(1)</u>		MRB (QSI042) Approval DAS <u>9</u> <u>17-06-26</u> <u>DAS</u> <u>9-89</u> <u>12</u> <u>9-89</u>																																																																																									
Description Work Order Deviation				Disposition		Completed By DAS <u>14</u> <u>9-89</u> <u>17-06-26</u> Lead hand / Supervisor Approval Verification DAS <u>30</u> <u>9-89</u> <u>JUN 26 2017</u> QC / QA Coordinator Approval <u>PD</u> <u>17-06-26</u>																																																																																									
tank support D4062-042 does align with bottom of tank 2.C. sediment bowl D4125-1/3 move during welding. No proper tooling to prevent bottom bowl to move during welding.				Remove material on both end of D4062-041 to allow it to align with bottom of the tank Thinnest wall is 0.280 after trimming. Acceptable. Part is simply a spacer and is not structural at the bolt connections. <u>17/06/26</u>																																																																																											
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☒</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☒	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>☒ Part Moved</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	☒ Part Moved	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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Work Order ID 160434

Thursday, April 27, 2017 11:36:28 AM

160434

Page 9

Item ID: D4464-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 5/23/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/13/2017 Req'd Qty: 1.00 *1*

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.10							
Quality Control									

JUN 27 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>								Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER : _____																									

Picklist Print

Thursday, April 27, 2017 11:36:27 AM

Page 1

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG
REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG
REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG REV.F DD
VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD
VERF:JLM IPP REV:H 15.03.04 AS PER DWG REV.H9 DD
VERF:JLM IPP REV:I 15.06.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-6

Purchased

No

190

Each

1,781.000

8

8

MS20470AD4-6

Rivet, Universal Head

**

17/06/09 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

323

m133077

323

ST310

1458

m136787

1458

D3999-7

Manufactured

No

120

Each

10.0000

1

1

D3999-7

Corner

**

17-6-13

Location

Loc Qty

Loc Code

WA003

10

108621

3

154230

1

156521

6

D4000-1

Manufactured

No

120

Each

2.0000

1

1

D4000-1

Fuel Supply Fitting

**

17/06/09 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

2

153006

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Thursday, April 27, 2017 11:36:27 AM

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4000-5 Manufactured No

120

Each

6.0000

1

1

✓ ***D4000-5***

Fuel Tank Vent Fitting

16 17-6-13

Location

Loc Qty

Loc Code

WA003

6

107388

3

152339

3

D4000-9 Manufactured No

120

Each

24.0000

3

D4000-9

Grommet

17/06/09 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

24

152269

24

D4000-045 Manufactured No

120

Each

5.0000

1

1

D4000-045

Fuel Pickup Fitting Assembly

17/06/09 DAS 36 9-89

Location

Loc Qty

Loc Code

WA003

5

157379

5

D4008-11 Manufactured No

120

Each

5.0000

1

1

D4008-11

Hinge Half

17/06/09 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

5

129867

2

154386

1

156452

2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐															
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐															
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐															
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐															
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐															
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐															
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐															
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐															
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐															
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

Picklist Print

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Page 3

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4057-1 Manufactured No

120 Each

55.0000

3 3

D4057-1

Retaining Ring

**

DAS
36
9-89
17/06/07

Location

Loc Qty

Loc Code

GA

5

107269

5

WA003

50

156450

50

3

D4125-1 Manufactured No

120 Each

6.0000

1 1

D4125-1

Fwd Sediment Bowl

**

11 17-6-13

Location

Loc Qty

Loc Code

WA003

6

156449

6

120

Each

6.0000

1 1

1x

D4125-3 Manufactured No

D4125-3

Aft Sediment Bowl

**

11 17-6-13

Location

Loc Qty

Loc Code

WA003

6

156459

6

120

Each

4.0000

2 2

1x

D4404-5 Manufactured No

D4404-5

Cushion, Fwd

**

DAS
6
9-89
JUN 22 2017

Location

Loc Qty

Loc Code

ST095

4

156461

4

160 607

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Picklist Print

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Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4462-1 Manufactured No

112 Each 2.0000 1 1

D4462-1

Baffle

**

DAS
36
9-89

17/06/05

Location

Loc Qty

Loc Code

WA003

2

154543

2

D4462-3 Manufactured No

112 Each 3.0000 1 1

D4462-3

Baffle

**

DAS
36
9-89

17/06/05

Location

Loc Qty

Loc Code

WA003

3

154385

1

157397

2

D4463-041 Manufactured No

120 Each 2.0000 1 1

D4463-041

Tank Top Assembly

**

17-6-7

Location

Loc Qty

Loc Code

WA003

2

156437

2

159870

1x

D4463-3 Manufactured No

120 Each 4.0000 1 1

D4463-3

Tank Aft End

**

17-6-7

Location

Loc Qty

Loc Code

WA003

4

154384

3

157410

1

1x

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4463-5 Manufactured No

120 Each 6.0000 1 1

D4463-5

Tank Upper Cut Out

**

CC 17-6-7

Location

Loc Qty

Loc Code

WA003

6

106751

6

D4968-1 Manufactured No

190 Each 4.0000 1

D4968-1

Side Cushion

**

DAS
6
JUN 22 2017 9:30

Location

Loc Qty

Loc Code

ST400

4

156463

4

D4023-3 Manufactured No

190 Each 6.0000 1 1

D4023-3

Cap And Flange

**

CC 17-5-31

Location

Loc Qty

Loc Code

WA003

6

122537

1

132479

1

152210

1

154435

3

D4463-7 Manufactured No

120 Each 2.0000 1 1

D4463-7

Tank Fwd End

**

CC 17-5-7

Location

Loc Qty

Loc Code

WA003

2

156506

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____					

Picklist Print

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Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4025-5 Manufactured No

190 Each 9.0000 1 1

D4025-5

Fuel Quantity Sender

DAS

36

9-89

JUN 22 2017

Location	Loc Qty	Loc Code
ST240	9	
147065	4	
154427	2	
156462	3	

D4463-9 Manufactured No

112 Each 2.0000 1 1

D4463-9

Tank Back

DAS

36

9-89

Location	Loc Qty	Loc Code
WA003	2	
158442	2	

D4463-11 Manufactured No

112 Each 3.0000 1 1

D4463-11

Tank Front

Location	Loc Qty	Loc Code
WA003	3	
154387	2	
157400	1	

D4577-1 Manufactured No

190 Each 6.0000 1 1

D4577-1

Rear Access Panel

Location	Loc Qty	Loc Code
WA003	6	
146093	4	
156515	2	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																																
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Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power Loss/Surge ☐</td><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Bending ☐</td><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio/Program ☐</td><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wrong Stock Pulled ☐</td><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td><td style="border: none;">Turning Sequence ☐</td></tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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		OTHER : ☐																																																																					

Picklist Print

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Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D3997-29	Manufactured	No	190	Each	4.0000	1	1		DAS
D3997-29									6
Placard									9-89
								JUN 2 2 2017	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST066	4	
152611	4	11/8/2017
		2

D3997-5	Manufactured	No	190	Each	8.0000	2	2		DAS
D3997-5									6
Placard									9-89
								JUN 2 2 2017	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST066	8	
156464	6	2/14/2017
154447	2	12/23/2017

D3997-17	Manufactured	No	190	Each	9.0000	1	1		DAS
D3997-17									6
Placard									9-89
								JUN 2 2 2017	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST066	9	
157362	6	11/8/2017
152258	3	

D3997-43	Manufactured	No	190	Each	10.0000	1	1		DAS
D3997-43									6
Placard									9-89
								JUN 2 2 2017	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST069	10	
152179	6	11/8/2017
157334	4	3/7/2018

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Page 8

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

190

Each

789.0000

13

13

NAS1149D0332.J

Washer

DAS

6

9-89

JUN 22 2017

Location

Loc Qty

Loc Code

FP

260

m136015

8

m137075

252

FP001

23

m137075

23

GA

138

m136643

138

ST264

368

m136015

0

m136643

368

137736

D4463-13

Manufactured

No

190

Each

3.0000

1

1

D4463-13

Tank Bottom

CC 17-6-7

Location

Loc Qty

Loc Code

WA003

3

154417

2

156497

1

1x

D4975-1

Manufactured

No

190

Each

2.0000

1

1

D4975-1

Bracket

17/06/09

DAS

36

9-89

Location

Loc Qty

Loc Code

WA003

2

154509

2

1

Thursday, April 27, 2017 11:36:28 AM

Shop Packet Print

Page 8

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐		Drill Holes ☐	Misaligned/off center ☐		Turning Sequence ☐																	
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							

Picklist Print

Thursday, April 27, 2017 11:36:28 AM

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4008-041 Manufactured No

190 Each 7.0000 1 1

D4008-041

Fuel Filler Splash Guard Assembly

JUN 22 2017

DAS

6

9-89

Location Loc Qty Loc Code

ST243 7
154405 5
157608 2

157608

AN3-5A Purchased No

169 Each 325.0000 24 24

AN3-5A

Bolt

JUN 22 2017

DAS

6

9-89

Location Loc Qty Loc Code

FP001 4
m136182 4
GA 250
m136986 250
ST350 71
m136182 71

24

MS21042L3 Purchased No

190 Each 1,852.000 4 4

MS21042L3

Nut

JUN 22 2017

DAS

6

9-89

Location Loc Qty Loc Code

FP001 91
m135945 91
GA 464
m134360 102
M136665 362
ST303 1297
m137073 11
m137166 286
m137321 1000

137680

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, April 27, 2017 11:36:28 AM

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

AN3H5A Purchased No

190 Each 22.0000 5 5

AN3H5A

Bolt

**

JUN 22 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST350

22

m136406

22

D3997-11 Manufactured No

190 Each 4.0000 1 1

D3997-11

Placard

**

JUN 22 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST066

4

152610

4

11/8/2017

AN3-7A Purchased No

190 Each 250.0000 4 4

AN3-7A

Bolt

**

DAS
6
9-89 JUN 22 2017

Location

Loc Qty

Loc Code

ST349

250

m137164

250

D4577-3 Manufactured No

190 Each 5.0000 1 1

D4577-3

Middle Access Panel

**

DAS
6
9-89 JUN 22 2017

Location

Loc Qty

Loc Code

WA003

5

146801

4

156440

1

17/06/22 DAS
36
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Thursday, April 27, 2017 11:36:28 AM

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

D4062-041 Manufactured No

190 Each 5.0000 1 1

D4062-041

Tank Support Assembly

**

Location

Loc Qty

Loc Code

WA003

5

145585

5

MS20426AD4-4 Purchased No

190 Each 2,758.000 4 4

MS20426AD4-4

Rivet

**

Location

Loc Qty

Loc Code

GA

1263

125445

1263

ST312

1495

m132536

1495

D4577-041 Manufactured No

190 Each 5.0000 1 1

D4577-041

Fwd Access Panel Assembly

**

Location

Loc Qty

Loc Code

WA003

5

146803

4

157348

1

MS20470AD4-4 Purchased No

190 Each 1,279.000 165 165

MS20470AD4-4

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

GA

899

M136851

181

M137166

718

ST310

380

M132803

380

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
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Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
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LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
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Thursday, April 27, 2017 11:36:28 AM

Work Order ID: 160434

160434

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 5/23/2017

Required Date: 6/13/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

949.0000

24

24

NAS1149D0363.J

Washer

JUN 22 2017

DAS
6
9-88

Location

Loc Qty

Loc Code

GA

42

m134055

42

ST263

907

m137061

100

m137164

807

137587

NAS 1149D0016 J

M134502

(IX)

17/06/26

DAS
36
9-88

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
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Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-3	FUEL CAP AND FLANGE
14	1	D4025-5	FUEL SENDER
15	3	D4057-1	RETAINER
16	1	D4062-041	TANK SUPPORT
17	1	D4125-1	FWD SEDIMENT BOWL
18	1	D4125-3	AFT SEDIMENT BOWL
19	2	D4404-5	CUSHION, FWD
20	1	D4462-1	BAFFLE
21	1	D4462-3	BAFFLE
22	1	D4463-041	TOP TANK ASSEMBLY
23	1	D4463-3	TANK AFT END
24	1	D4463-5	TANK UPPER CUT OUT
25	1	D4463-7	TANK FORWARD END
26	1	D4463-9	TANK BACK
27	1	D4463-11	TANK FRONT
28	1	D4463-13	TANK BOTTOM
29	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
30	1	D4577-1	REAR ACCESS PANEL
31	1	D4577-3	MIDDLE ACCESS PANEL
32	1	D4968-1	CUSHION, SIDE
33	1	D4975-1	ANGLE BRACKET
34	24	AN3-5A	BOLT
35	5	AN3H5A	BOLT
36	4	AN3-7A	BOLT
37	4	MS20426AD4-4	RIVET, CSK
38	165	MS20470AD4-4	RIVET, PANHEAD
39	8	MS20470AD4-6	RIVET, PANHEAD
40	4	MS21042L3	NUT
41	13	NAS1149D0332J	WASHER
42	24	NAS1149D0363J	WASHER

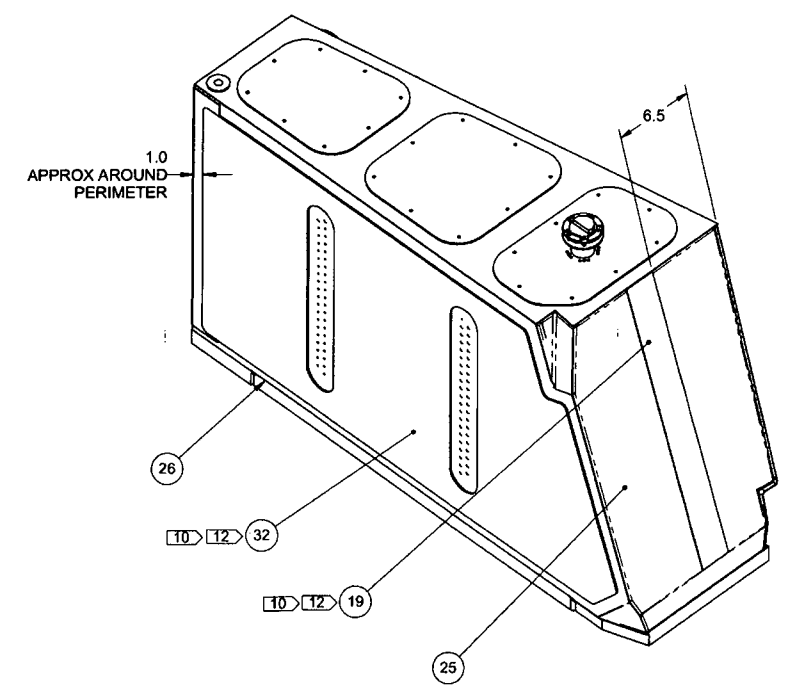
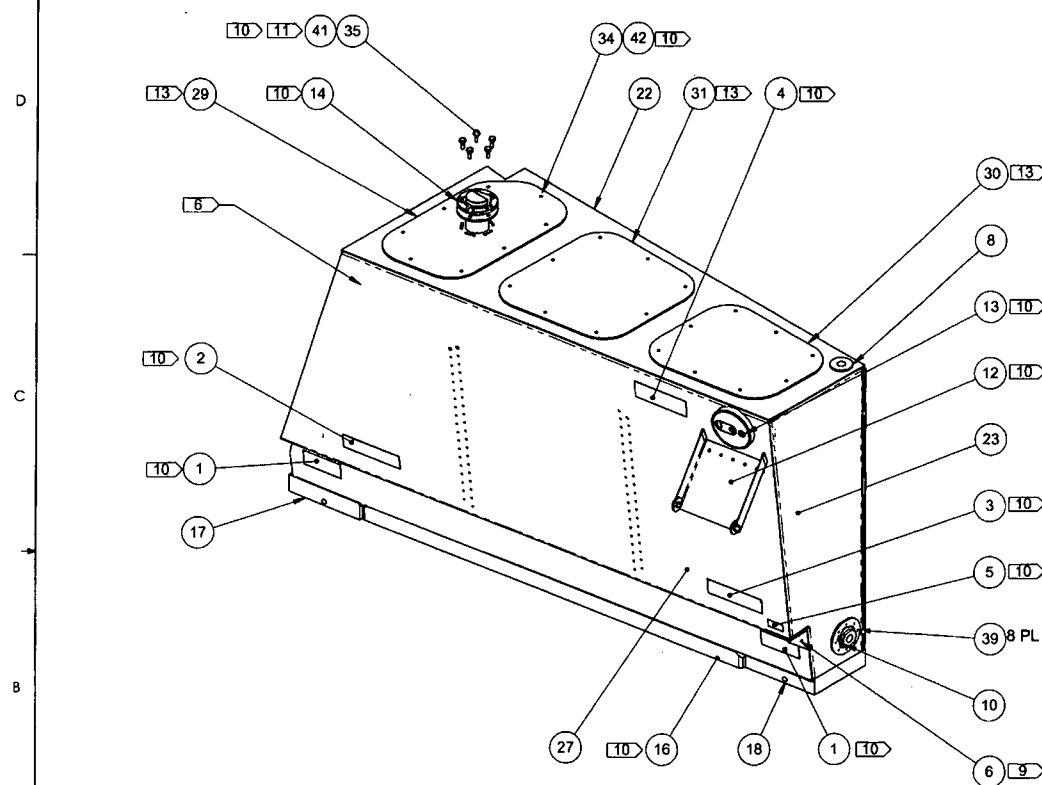
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160434
APR 27 2017

RELEASED
2015-06-18
ECN 15-583

H	REPLACED NOTE 8 (SHT 2), ADDED NOTE 14 (SHT 2), ADDED AUXILIARY VIEW (SHT 3), ADDED NOTE 15 (SHT 4), REPLACED NOTE 13 (SHT 5), SHT 4 WAS SHT 3, SHT 5 WAS SHT 4, REMOVED D4124-1 TABS & AN3-6A BOLTS, CHEMICAL CONVERSION COAT NOW AFTER WELDING (SHT 5), ADD AN3-7A BOLTS	CC	15.02.06
G	FINISH "FLAT GREY" WAS "GREY" (SHT 2); PICTORIAL UPDATE FOR D4000-1 & D4462-1	AP	14.12.05
F	AN3-5A WAS AN3C4A QTY. 24 (ZN D6-2) AN3H5A WAS AN3-5A QTY. 5 (ZN D7-2) MS20470AD4-6 WAS MS20426AD4-6 QTY. 8 (ZN B5-2) D4000-1 IS NO LONGER INSTALLED WITH COUNTERSUNK RIVETS UPDATE NOTE 10 ON SHEET 3	ML	14.06.27
E	UPDATED -041 WITH RE-DESIGNED D4463-3/-8/-11 AND D4462-1/-3. D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35208-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B5-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B5-2, UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13, ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	CC	
CHECKED	AP	DRAWING NO. REV. H
MFG. APPR.	DD	D4464 SHEET 1 OF 5
APPROVED	HS	TITLE SCALE
DE APPR.	DS	TANK ASSEMBLY NTS
DATE	15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY

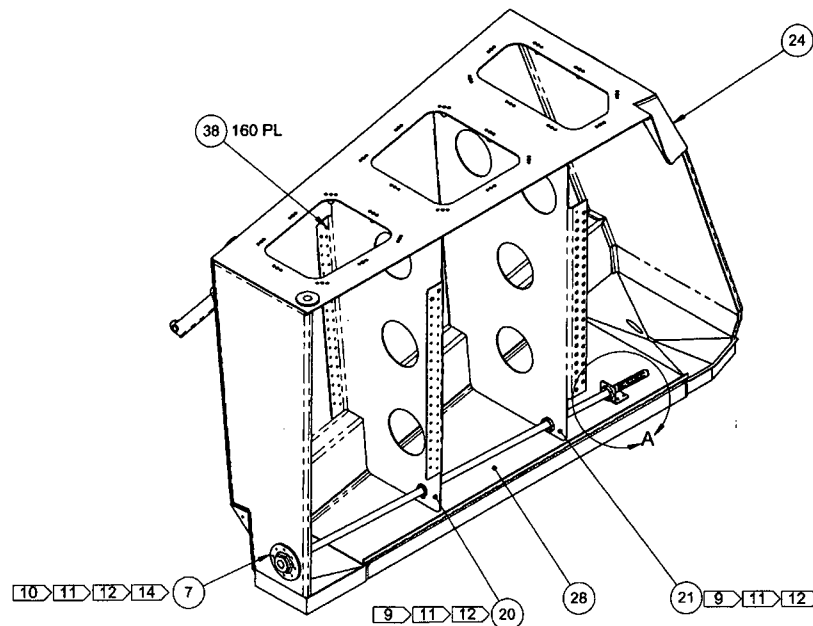
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 39.52 lbs
- 8) LPI AND PRESSURE TEST PER DART QSI 038 6.3
- 9) MASK PRIOR TO FINISH
- 10) INSTALL AFTER FINISH
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-1/-3 ACCESS PANELS WET WITH PROSEAL P/S 890B.

RELEASED
2015-06-18

APPROVED	DESIGN	ML	DART AEROSPACE LTD	
	DRAWN	CC	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. H
	MFG. APPR.	DD	D4464	SHEET 2 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	TANK ASSEMBLY	NTS
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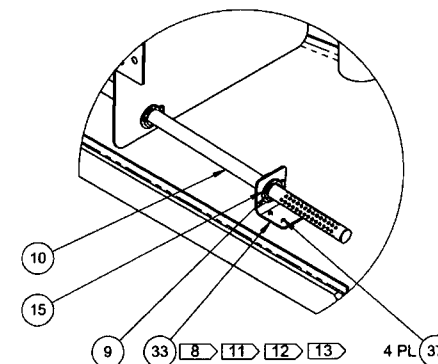
8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY 
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\phi 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\phi 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK
- 14) INSTALL D4000-1 FITTING WITH FLAT FACING UPWARDS
- 15) BRUSH PROSEAL 890A ON ALL INTERNAL SHEET METAL FOLDS

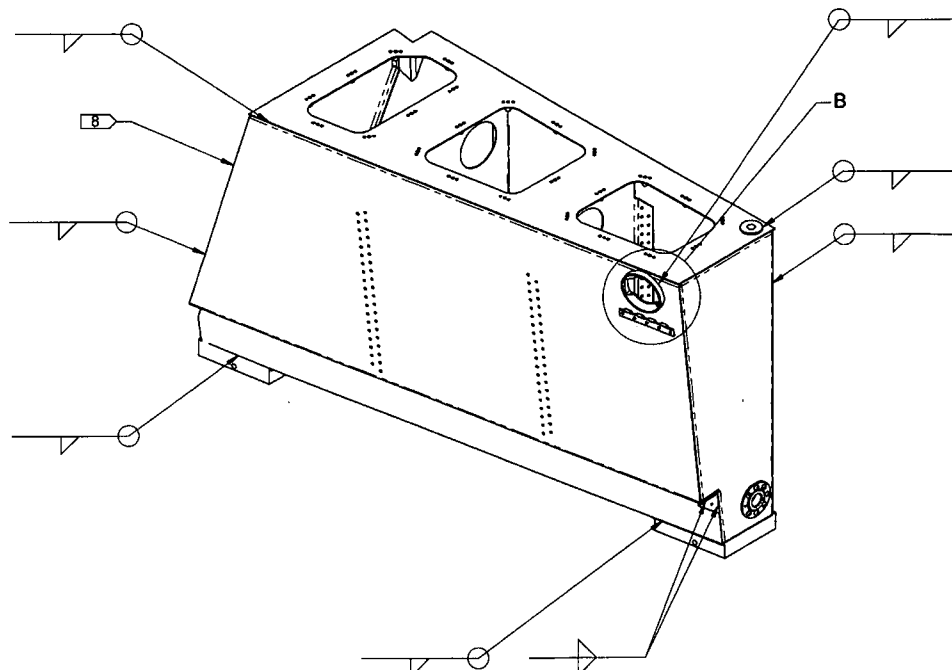


DETAIL A
ROTATED FOR CLARITY
SCALE 2X

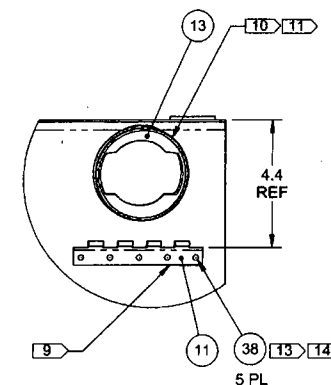
RELEASED
2015-06-16

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
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D4464-041 FUEL TANK ASSEMBLY 
WELDING AND RIVETING DETAIL



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

NOTES:

-  1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
9) CENTER HINGE BELOW FUEL CAP FLANGE
10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
12) WELD PER DART QSI 004
13) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
14) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

RELEASED
2015-06-16 

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36696**

Purchase Order Date 6/14/2017

PO Print Date 6/21/2017

Page Number 1 of 5

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71401-45	procurement quality clauses	6/21/2017 No 6/21/2017		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents						
Line Total:							\$0.00
2	160434	D4464-041 AUX TANK	6/21/2017 Yes 6/21/2017		1.00	\$147.00	\$147.00
	LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						

Note:

6/21/2017

6/21/2017 - 6-21

DAS
38
9-89



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO32445	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO36696
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 9 CROSSTUBES AND 1 FUEL TANK ASSY AS PER PO36696

2 AFT CROSSTUBES , ITEM ID# D206-667-207BL , WORK ORDERS ID# 162193, 162195

1 FUEL TANK ASSY , ITEM ID# D4464-041 , WORK ORDER ID# 160434

3 AFT CROSSTUBES , ITEM ID# D119-796-241 , WORK ORDERS ID# 158475, 161227, 161228

4 AFT CROSSTUBES , ITEM ID# D407-667-205 , WORK ORDERS ID# 160197, 160199, 160201, 160202

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13						JUN 16 2017	
MULTIPLE LEAK FOUND ON FUEL TANK ASSY							
REMAINING ITEMS: NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , EMU. MPO15896, DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	
		DAS					
		38					
		3-85					

JUN 21 2017

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		JUN 16 2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36750

Purchase Order Date 6/19/2017

PO Print Date 6/21/2017

Page Number 1 of 3

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact

Ship To Phone

Ship Via: Delivered

Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71401-45	procurement quality clauses	6/21/2017 No 7 9:56:00 AM		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents						

Line Total: \$0.00

2	160434	D4464-041 AUX TANK	6/21/2017 Yes 7 9:56:00 AM		1.00	\$0.00	\$0.00
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LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

DAS
38
9-89

Note:

6/21/2017



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO32469	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO36750
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 4 CROSSTUBES + 1 FUEL TANK

ITEM ID: D206-667-207BL AFT CROSSTUBE - MID HEIGHT 206L/L1/L3/L4 BLUE. (QTY4)

1 - WORK ORDER ID#: 162198

2 - WORK ORDER ID#: 162194

3 - WORK ORDER ID#: 162196

4 - WORK ORDER ID#: 162197

ITEM ID: D4464-041 FUEL TANK (QTY1)

5 - WORK ORDER ID#: 141833

SP176-21

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-5) AS PER ASTM1417M-13						JUN 20 2017	
NO CRACK FOUND							
Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

DAS
38
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp DOT-APP 61 53-89	Date: JUN 20 2017
Name:			

ANTONINO MARCHETTA